DACRYLATE HIGH PERFORMANCE COATINGS

BY APPOINTMENT TO
HER MAJESTY THE QUEEN
MANUFACTURERS OF PAINT, VARNISHES & EMULSIONS
DACRYLATE PAINTS LTD.,
NOTTINGHAM

PRODUCT DATASHEET

Etch Primer (One-Pack)

PRODUCT INFORMATION

Reference Number:
78-LINE

Coating type:
Single-reinforced PVB with zinc phosphate inhibitive pigment

Typical uses:
To provide good adhesion to mild steel and non-ferrous metals, for example, zinc, galvanising. Also used as blast/holding primer for mild steel and as a sealer for aluminium and zinc metal spray.

Colours available:
White (78-1)
Dark Grey (78-7)
Grey (78-65)
Light Grey (78-6)
Black (78-24)
Black (E/S) (78-83)

Appearance:
Smooth, low sheen

Features and benefits:
- Multi-purpose product than can be used in a variety of scenarios

TECHNICAL INFORMATION

Theoretical coverage:
11.3m^2 per litre at 15 microns dry film thickness

Film thickness:

	Wet film thickness	Dry film thickness
Typical:	90 microns	15 microns
Range:	60-120 microns	10-20 microns

Recommended primers:
Not applicable

V.O.C.:
664grm/ltr EPA Method 24
692grm/kg calculated from formulation to satisfy EU Solvent Emissions Directive
May vary with colour

% Volume solids:
17% calculated from laboratory formulation
May vary with colour

Drying time:

Temp.	Touch dry	Firm dry	Overcoat
5ºC	12-25 mins	75 mins	After 3 hrs 45 mins
10ºC	10-20 mins	60 mins	After 3 hrs
15ºC	7-15 mins	45 mins	After 2 hrs 15 mins
20ºC	5-10 mins	30 mins	After 90 mins

Drying time will vary with temperature, air movement, etc.

SURFACE PREPARATION

Paint preparation before use:
Make sure that the paint is stirred well before use, making sure the bottom of the can is stirred as well to ensure the paint is mixed well.

Mixing ratio by volume:
N/A

Surface preparation:
All surfaces to be coated should be clean, dry, and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000

Steel:
Preferred method is abrasive blast to BS: 4232 Second Quality.

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SURFACE PREPARATION

Manual cleaning:
Chip, scrape, and power wire brush to remove all loose millscale, rust and other surface contaminants.
Degrease with Dacrylate Thinner R11.

Zinc, galvanising, etc.:
Thoroughly degrease with Dacrylate Thinner R11.

APPLICATION

Application conditions:
This material should preferably be applied at temperatures more than 10°C. Relative humidity should not exceed 90% and in these conditions good ventilation is essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C.
At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Airless spray:
Tip size: Approx. 11 thou (0.279mm)
Tip pressure: 2000psi (138bar)

Conventional spray:
Tip size: 55 thou (1.4mm)
Tip pressure: 40-60psi (2.7-4.1bar)

Brush application:
This product is not suitable to be brushed

Roller application:
This product is not suitable to be rolled.

Dipping:
Thin with Dacrylate Thinner R38 as required to achieve uniform film build.

Thinning:
25% of Dacrylate Thinner R11 may be required when conventional spraying the product to achieve optimum spray characteristics.

Clean-up:
Clean all equipment after use with Dacrylate Thinner R11. Do not allow product to remain in hoses, guns, or spray equipment. All surplus product should be disposed of in accordance with appropriate regional regulations/legislation.

STORAGE AND PACKAGING

Storage:
Under cover within temperature range of 5°C to 32°C. Keep containers dry and tightly sealed to avoid moisture contamination.

Shelf life:
6 months or longer in unopened containers when stored under cover within a temperature range of 5°C to 32°C.

Pot life (at 20°C):
N/A

Packaging:
5 litre tins

HEALTH AND SAFETY

Please refer to the following data sheets:

78-1 10198 One-Pack Etch Primer
78-6 10355 One-Pack Etch Grey
78-7 20290 One-Pack Etch Primer
78-24 20291 One-Pack Etch Primer
78-65 20295 One-Pack Etch Primer
78-83 10806 One-Pack Etch Primer

All work involving the application and use of this product should be performed in compliance with all relevant national, health, safety & environmental standards, and regulations

ADDITIONAL NOTES

The airless spray information given above is intended as a guide only. As conditions vary from job-to-job, it is the applicators responsibility to ensure all equipment in use has been set up to give the best results.

One-Pack Etch Primer(s) can be supplied in E/S quality (78-83) or alternatively, E/S additive may be post-added to achieve the necessary electrical resistance.

IMPORTANT INFORMATION

The information supplied in this product datasheet is not intended to be exhaustive. Any person using the product for any other purpose than that specifically recommended in this product datasheet, without first obtaining written confirmation from Dacrylate Technical Services as to the suitability of the product for the intended purpose does so at their own risk. All advice given about the product is correct to the best of our knowledge, however we have no control over the condition of the substrate, preparation or the many factors affecting the use and application of the product. Therefore, unless specifically agreed in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product.

Dacrylate warrants its products to be free from defects in material and workmanship. Dacrylate's obligations and buyer's exclusive remedy relating to the products shall be limited, at Dacrylate's option, to either replace the products not conforming the warranty or the credit of the buyers account in the invoiced amount of the non-conforming product. Any claim under this warranty must be made by the Buyer to Dacrylate in writing within five (5) days of the Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. The Buyer's failure to notify Dacrylate of such non-conformance as required herein shall bar the Buyer from recovery under this warranty.

The information detailed in this datasheet is liable to modification from time-to-time in the light of experience and our programme of product development. Before use, it is the customers responsibility to check with Dacrylate Customer Services, quoting the product reference number and version reference at the bottom of the data sheet, to ensure that they have in their possession the latest issue.

Technical product datasheets are available from our website at www.dacrylate.co.uk, and should be the same as this datasheet. Should there be any discrepancies between this document and the website version, then please contact Dacrylate Customer Services.

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